Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 3,8mm

Order data

Order number	123115 3,8
GTIN	4045197401625
Item class	11E

Description

Version:
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.**
Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!
Straight major cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.
Advantage:
High process reliability and surface quality of the hole.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.

Technical description

Nominal Ø D_C	3.8 mm
Feed f in stainless steel < 900 N/mm^2	0.08 mm/rev.
Flute length L_c	48 mm
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal Ø	h7
Shank Ø D_s	6 mm
Overall length L	86 mm
Standard	Manufacturer’s standard

recommended maximum drilling depth L_2	42.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	10×D
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	**V_c**	**ISO code**
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	180 m/min	N
Steel < 500 N/mm²	suitable	110 m/min	P
Steel < 750 N/mm²	suitable	80 m/min	P
Steel < 900 N/mm²	suitable	70 m/min	P
INOX < 900 N/mm²	suitable	65 m/min	M
INOX > 900 N/mm²	suitable	55 m/min	M
Ti > 850 N/mm²	suitable	25 m/min	S
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		